



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3407-043
Job Sheet 200944



Part No: D3407-043

Job Qty: 10 pcs

Part Name: Tow Ring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Handwritten: DWG D3407 Rev. G

Handwritten: DAS 35 9-80

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	10 pcs	10/10/19		0.00	2.08	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		<i>MR Nov 7/19</i>
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	10 pcs	10/10/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		<i>EL</i>
							QC 9 - 9		
120	QC 5	10 pcs	10/10/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A
CANADA
TEL: 1 613 632-5200
Email: sales@dartae
www.dartaerospace.ca

Container No: S229819



Job No: D3407-043

Job No: 200944

Job No/Batch: S229819

Revision: G

Sector:

130	Powdercoat - 1 White GI(A)- B4B	10 pcs	10/10/19	0.00 0.38	QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
140	QC 3	10 pcs	10/10/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150	Packaging 3-1 - Stock - B4B	10 pcs	10/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	10 pcs	10/10/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9:59

NOV 20 2019

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____) Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & Descriptions: QSI 004 A/R TIG174 ROD Batch: M102576

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) **Mask Threaded Section** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

140 - (QC3- Inspect Part Finish)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3407-3	Stem	10 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5197707</u>
D3407-5	Ring	10 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5206293/5217205</u> X1

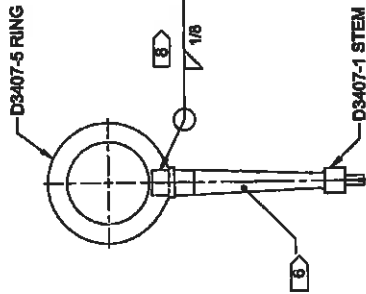
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3407-3	10	29	0
	D3407-5	10	1	0

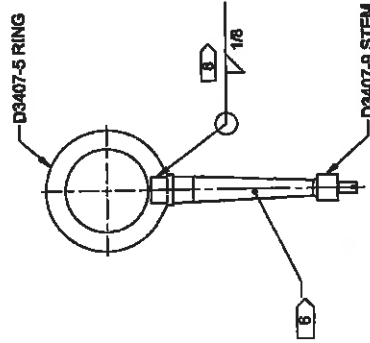
Part Specifications

Specifications could not be found.

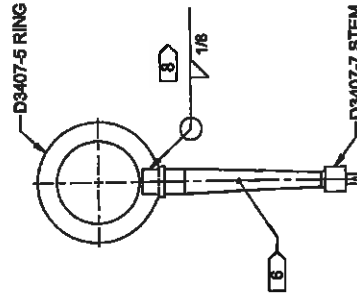
QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
			D3407-047	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
	1		D3407-7	STEM
		1	D3407-9	STEM



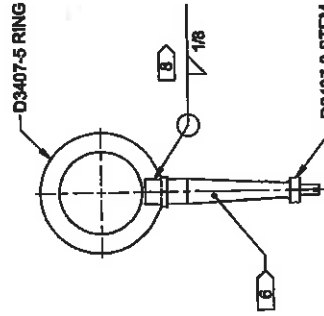
D3407-041 TOW RING



D3407-047 TOW RING



D3407-045 TOW RING



D3407-043 TOW RING

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: MASK THREADS PRIOR TO POWDER COAT
 - 3) TOLERANCES: PER DART QSI 005 4.3
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044, 6.1
 - 7) WEIGHT: D3407-041 - 0.89 lbs, D3407-043 - 0.63 lbs, D3407-045 - 0.61 lbs, D3407-047 - 0.58 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

RELEASED
2017-10-31
EAW 17-728

APPROVED

REV.	DESCRIPTION	DATE	BY
1	NEW ISSUE	17.08.07	
2	UPDATE DIAMETER, THREAD CLASS ADDED	05.08.17	
3	-1/3 LONGER FOR FIT W/ WASHES	05.08.09	
4	D3407-1/3 SLIT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C3-2, C3-3; D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B8-4); REASON: PRODUCTION FACILITY	08.04.07	
5	REASON: PRODUCTION FACILITY	08.07.23	
6	ADD D3407-045 (ZN B8-1, C3-1); ADD D3407-7 (ZN B8-5); ADD D3407-9 (ZN B8-5); ADD IDENTIFICATION (ZN A5-1);	17.05.10	
7	ADD D3407-047 (ZN B8-2, D6-2); ADD D3407-9 (ZN A5-7);	17.08.07	
8	REVISION NOTE 1 ON SHEET 4 AND SHEET 6 TO SPECIFY MATERIAL CONDITION		

DART AEROSPACE USA, INC.

EUGENE, OR

DRAWING NO.

D3407

REV. G

SHEET 1 OF 8

SCALE

NTS

TOW RING

DATE

17.08.07

BY

DATE

17.08.07

17.08.07

17.08.07

200944 MWS
19-09-19

Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____

DEPARTMENT/PROCESS

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Skid-tube ☐
Machining ☐
Large Fab ☐

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

MRB (QS042)

QTY Affected: _____

Sequence #: _____

Disposition

Description Work Order Deviation

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

FAULT CATEGORY

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐

Other/Details: _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐